

Date: Thursday, 10/25/2007 10:00:33 AM
User: Kim Johnston

Process Sheet

125

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 35342	
Estimate Number : 10198	
P.O. Number : N/A	Part Number : D21752
This Issue : 10/25/2007 S.O. No. : N/A	Drawing Number : D2175 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E
Previous Run : 31691	Material : N/A
	Due Date : 10/31/2007
Written By : <u>JA 07.10.25</u>	Qty: 30 Um: Each
Checked & Approved By : <u>JA 07.10.25</u>	
Comment : Est E 04.06.09 Reformat KJ/RF	
Est Rev:F 06-04-28 Manufactured on Water Jet JLM	
Est Rev:G As per Rev E 06-11-22 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 14.8743 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 105615 IB 07-10-25

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2175

Dwg Rev: E

Prog Rev: E

IB 07-10-25

(32)

2-Deburr if necessary

IB 07-10-25

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 07-10-25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 10/10/29 water X32

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

MA Done @ step # 2.2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 21/1/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:00:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 35342

Part Number: D21752

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/10/30 (32)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters
L 07/10/30 x32

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 07/11/01 (32)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

BR 07-11-01 (32)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-11-01 (32)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(32)
R 07/11/02

Job Completion



U 07-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35342
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

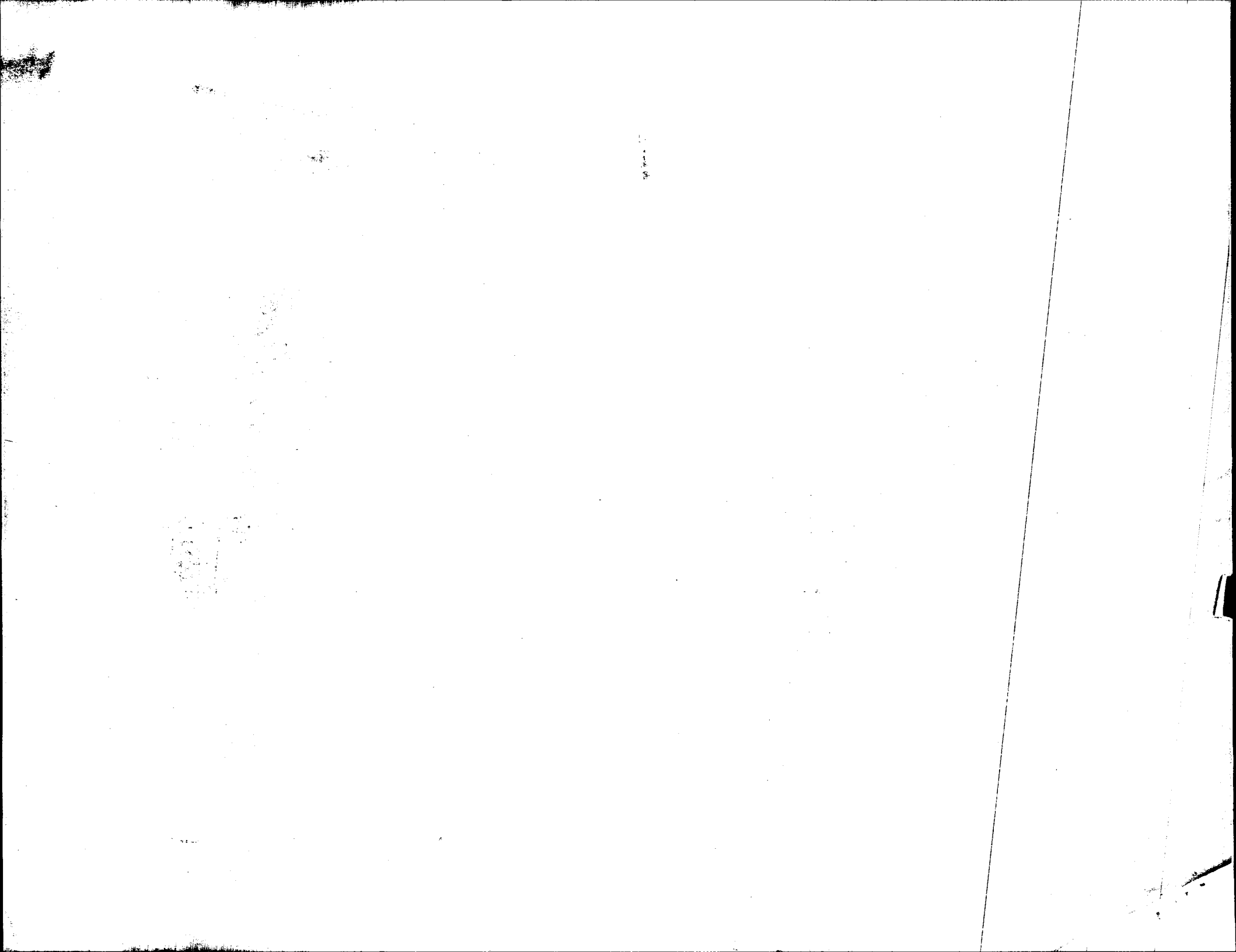
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	X			
R0.35	+/-0.030	.35	X			
2.915	+/-0.010	2.917	X			
50°	+/-0.5°	50°	X			
0.300	+/-0.010	.300	X			
1.050 Pitch	+/-0.010	1.050	X			
10.500	+/-0.010	10.500	X			
11.550	+/-0.010	11.550	X			
0.550	+/-0.010	.550	X			
0.900	+/-0.010	.900	X			
0.063 thick	+/-0.010	.063	X			
Grain Direction	N/A		X			
Ø0.128	+0.005/-0.001	.128	X			
Ø0.172	+0.005/-0.001	.172	X			

Measured by: RB	Audited by: G	Prototype Approval:	N/A
Date: 07-10-25	Date: 07/10/25	Date:	N/A

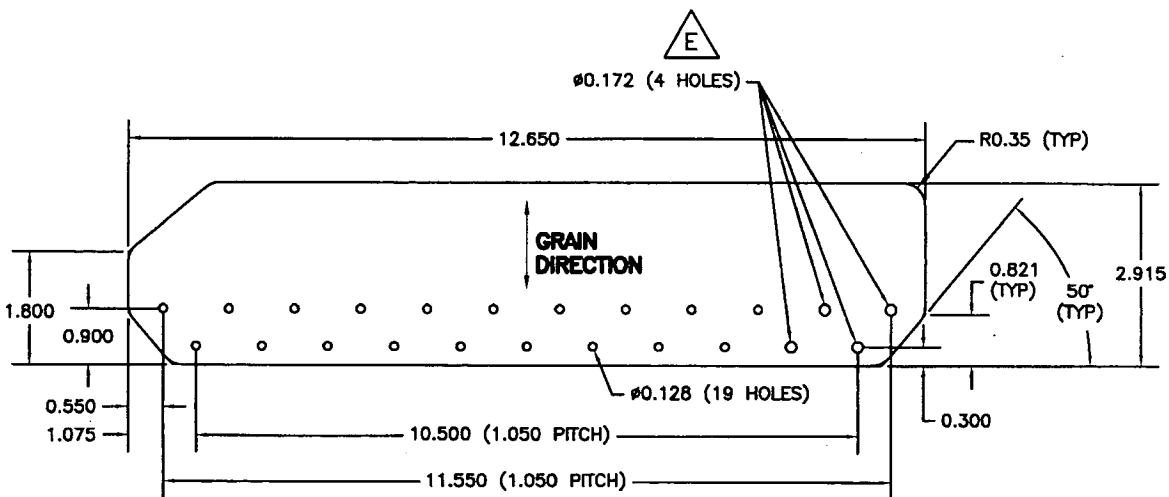
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	



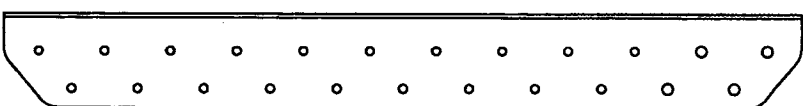


RELEASED
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		
RF	CE	DRAWING NO.	REV. E	
CHECKED PH	APPROVED [Signature]	D2175	SHEET 1 OF 1	
DATE 06.09.25		TITLE ANGLE	SCALE 1:3	
A	95.10.25	NEW ISSUE		
B	96.01.18	CHANGED DIMENSION		
C	00.09.11	UPDATE FINISH SPEC		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES		



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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NO. 33342

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